

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024985**Date Inspected:** 07-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lei/Wen/Shigang/Feng /Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 11

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 080 located on BK012A8-001. Welder is identified as 205649. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 070 located on BK011A3-001. Welder is identified as 044541. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09382.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK011A2-001-001, 003, 004, 005, 006, 007, 009, 010, 011, 012

BK011A3-001-019, 020, 043, 044, 032, 033, 058, 059, 005, 009, 030, 031, 056, 057, 021, 022, 045, 046, 002, 010, 138, 139, 140, 141

BK011A4-001-006, 007, 032, 033, 058, 059, 021, 022, 047, 048, 073, 074, 019, 020, 045, 046, 071, 072, 004, 005, 030, 031, 056, 057, 106, 107, 108, 109, 118, 119, 120, 121

BK011A5-001-004, 007, 002, 008, 112, 115, 118, 121, 122, 125, 128, 131

BK011A6-001-072, 073

BK011A8-001-072, 073

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09384.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK011A3-001-065, 067, 068, 100, 101, 102, 069, 070, 071, 103, 104, 105

BK011A4-001-080, 082, 083, 100, 101, 102, 085, 086, 087, 103, 104, 105

BK011A-001 – Step 10

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09382.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK011A2-001-001, 003, 004, 005, 006, 007, 009, 010, 011, 012

BK011A3-001-019, 020, 043, 044, 032, 033, 058, 059, 005, 009, 030, 031, 056, 057, 021, 022, 045, 046, 002, 010, 138, 139, 140, 141

BK011A4-001-006, 007, 032, 033, 058, 059, 021, 022, 047, 048, 073, 074, 019, 020, 045, 046, 071, 072, 004, 005, 030, 031, 056, 057, 106, 107, 108, 109, 118, 119, 120, 121

BK011A5-001-004, 007, 002, 008, 112, 115, 118, 121, 122, 125, 128, 131

BK011A6-001-072, 073

BK011A8-001-072, 073

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt, Scott	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
